

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007535**Date Inspected:** 21-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhao Chen Sun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG & TOWER components**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Dilip Chakrabarti was present during the times noted above for observations relative to the work being performed.

Bay# 6-OBG Assembly

This QA Inspector randomly observed the following work in progress:

Magnetic Particle Testing (MT):

For Green Tag:

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report on this date.

The member and the weld designations are as follows:

Sl # Section # Weld # Green Tag # Location

1. SP 3037-001 028,084 009431 12 AW

2. SP 3035-001 050,001 009429 12 1W

3. SP 3036-001 030,086 009430 ` 12 AW

4. CB 202C-008 01B,03B,04B NA NA

Bay# 6-Tower Assembly

This QA Inspector randomly observed the following work in progress:

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Magnetic Particle Testing (MT):

For Green Tag:

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report on this date.

The member and the weld designations are as follows:

Sl # Section # Weld # Green Tag # Location

1. ESD1-DPSA4-6 B/B-3 NA NA

SMAW Process:

Welding of weld joints# B/B-5 located on PCMK WSD1 DPSA4-6. Welder is identified as 066478. ZPMC QC is identified as Zhang Bao Bo. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3312-TC-P5.

Welding of weld joints# B/B-4 located on PCMK WSD1 DPSA4-6. Welder is identified as 037743. ZPMC QC is identified as Zhang Bao Bo. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3312-TC-P5.

SAW Process:

Root pass welding of weld joints# 1A located on PCMK ND1 SA 658-77M-2. Welder is identified as 054458. ZPMC QC is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3221-TC-U5-S-1.

Bay# 7-OBG Assembly

This QA Inspector randomly observed the following work in progress:

SAW Process:

Welding of weld joints#006 located on PCMK SP 3043-001. Welder is identified as 053748. ZPMC QC is identified as Zhong Dian Xing. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2221-B-L2C-S-2.

FCAW Process:

Welding of weld joints#53&54 located on PCMK SP 3046-001. Welder is identified as 053742. ZPMC QC is identified as Huang Min. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132-3.

Welding of weld joints#57&58 located on PCMK SP 3046-001. Welder is identified as 054459. ZPMC QC is identified as Huang Min. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132-3.

Welding of weld joints#49&50 located on PCMK SP 3046-001. Welder is identified as 062447. ZPMC QC is identified as Huang Min. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132-3.

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Bay# 8-OBG Assembly

This QA Inspector randomly observed the following work in progress:

SAW Process:

Welding of weld joints#002 located on PCMK CB 201E-012. Welder is identified as 207463. ZPMC QC is identified as Guo Yan Fie. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2221-B-L2C-S-2.

Unless otherwise noted, all work observed on this date appeared to be generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversation

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Chakrabarti,Dilip Kumar	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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